

Date: Monday, 3/20/2006 11:39:41 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLOWER MOTOR SUPPORT
Job Number : 26268	
Estimate Number : 12309	
P.O. Number : N/A	Part Number : D3471043
This Issue : 3/20/2006 S.O. No. : N/A	Drawing Number : D3471 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 26268	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 3/31/2006
Checked & Approved By : <u>SEE ABOVE USER & DATE</u>	Qty: <u>2</u> Um: Each
Comment : est rev A 06.03.02 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	MS3584216	CLAMP
-----	-----------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 pick:

Qty	Part number	Description	Batch
-----	-------------	-------------	-------

2	MS35842-16	CLAMP	B19691
---	------------	-------	--------

(2)

2.0	MS20427M44	RIVET
-----	------------	-------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
 pick:

Qty	Part number	Description	Batch
-----	-------------	-------------	-------

6	MS20427M4-4	Rivet	M100393
---	-------------	-------	---------

(6)

3.0	D34713	SUPPORT
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 pick:

Qty	Part number	Description	Batch
-----	-------------	-------------	-------

2	D3471-3	Support	B 26124
---	---------	---------	---------

(2)

SB 06/03/29

(2)

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3471

SB 06/03/29

(2)

Date: Monday, 3/20/2006 11:39:42 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26268

Part Number: D3471043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/03/29 (2)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/03/29 (2)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/03/30 (2)

Job Completion



CR 06-03-30

Date: Thursday, 3/16/2006 10:37:40 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLOWER MOTOR SUPPORT
Job Number	: 26268		
Estimate Number	: 12309		
P.O. Number	:	Part Number	: D3471043
This Issue	: 3/16/2006 S.O. No. :	Drawing Number	: D3471 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 3/31/2006 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: est rev A 06.03.02 New issue EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

MS3584216

CLAMP



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
CLAMP

Job Completion



Eric
could you
phase complete
and let me
know when
done
W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

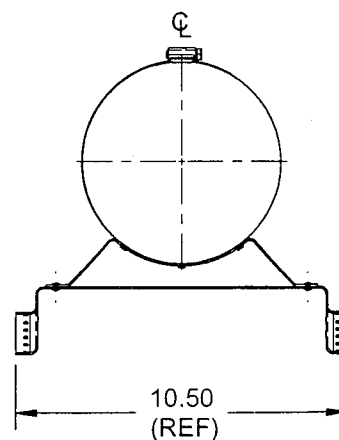
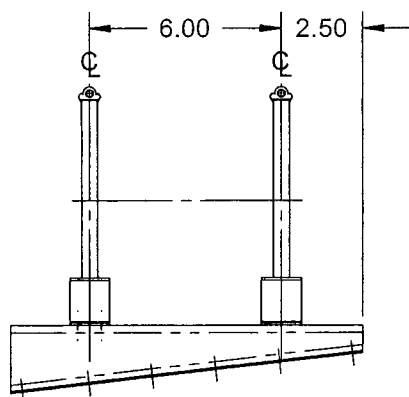
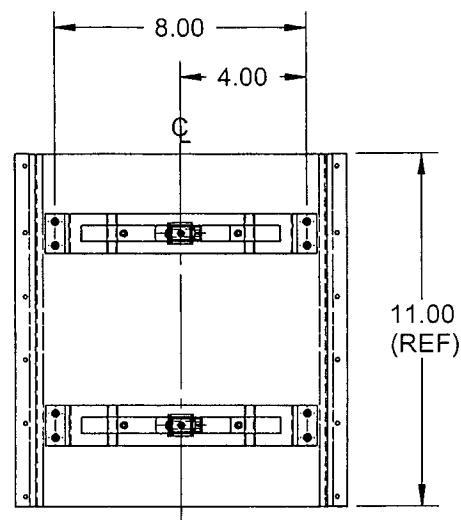
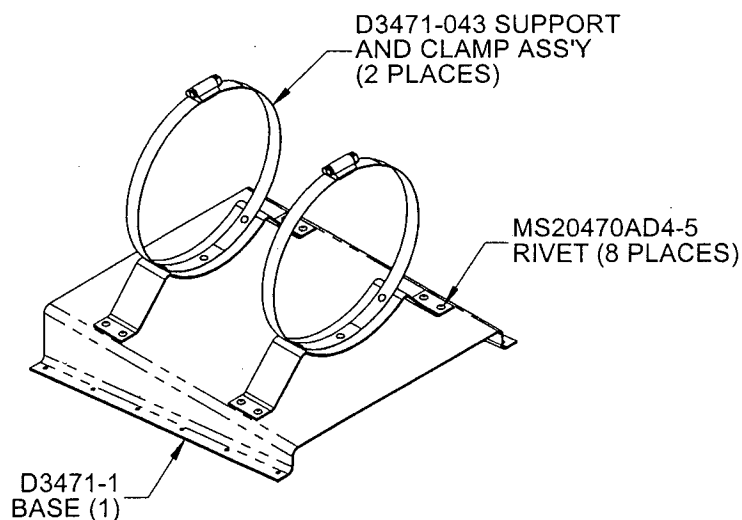
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/03/29	4	2 elamp u. 35842-16 + 1 D 3471-3 were scrap	<i>[Signature]</i> GARDIN	snaps - destroy replace it	gs 06/03/29	<i>[Signature]</i> GARDIN	<i>[Signature]</i> GARDIN	<i>[Signature]</i> GARDIN

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3471	REV. A SHEET 1 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:6
A	05.12.21	NEW ISSUE	



D3471-041 BLOWER MOTOR SUPPORT

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

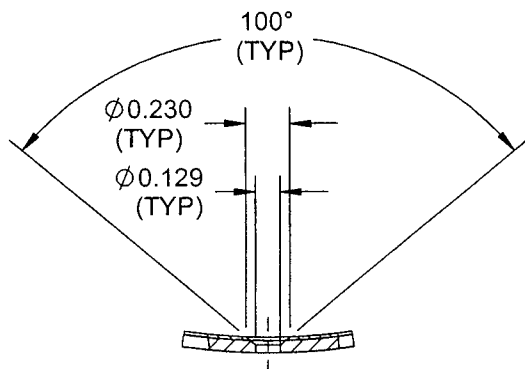
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26268

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

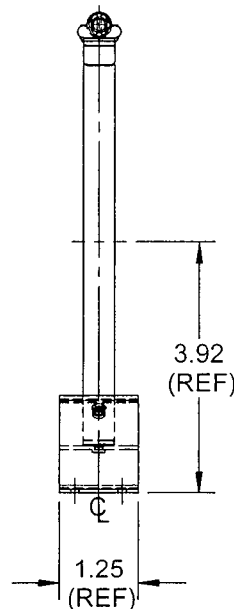
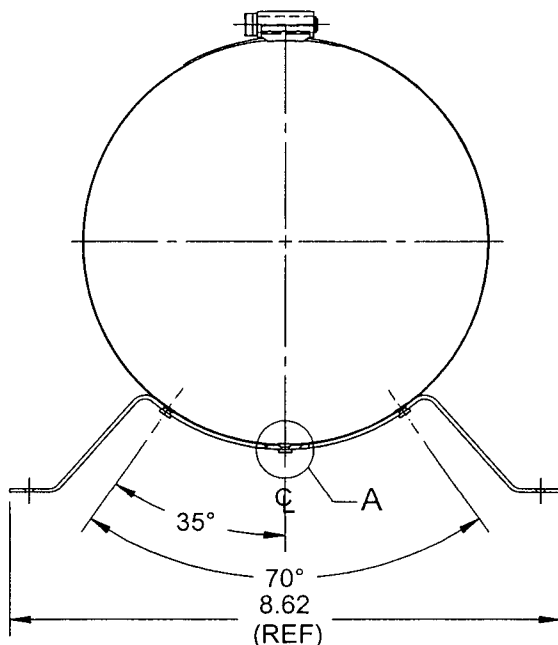
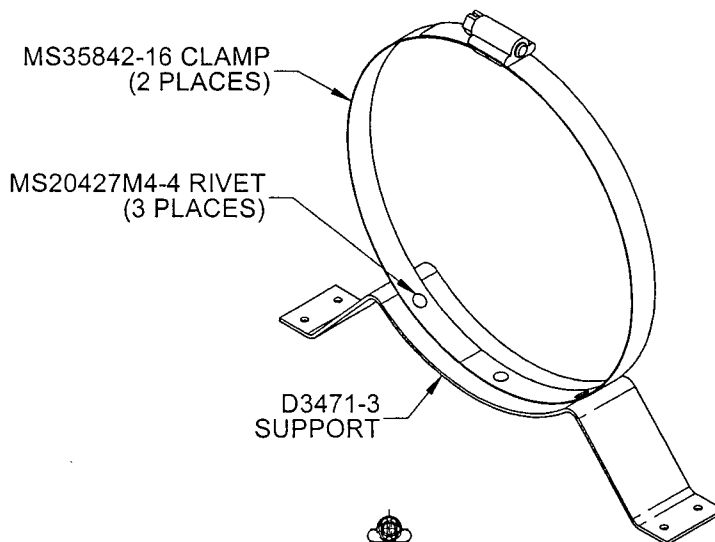
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3471	REV. A SHEET 2 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	
		SCALE 1:3	



DETAIL A: COUNTERSINK HOLES
(RIVET NOT SHOWN FOR CLARITY)
SCALE 1:1



D3471-043 SUPPORT AND CLAMP ASS'Y

NOTES:

- 1) LOCATE MS35842-16 CLAMP AND TRANSFER DRILL #30 (0.129") HOLES FROM D3471-3 TO MS35842-16 CLAMP. COUNTERSINK AS SHOWN IN DETAIL A (3 PLACES).
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

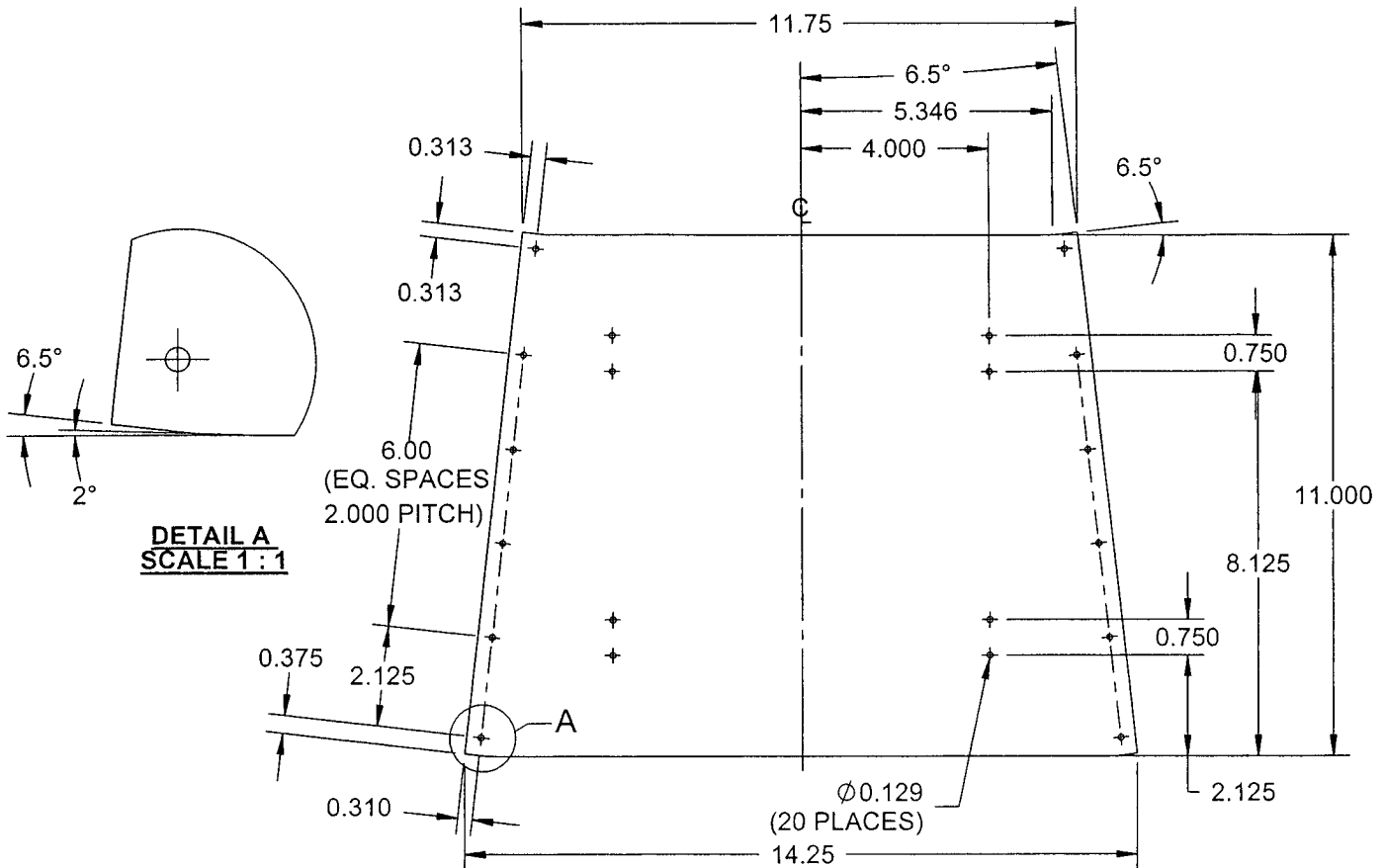
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **26268**

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

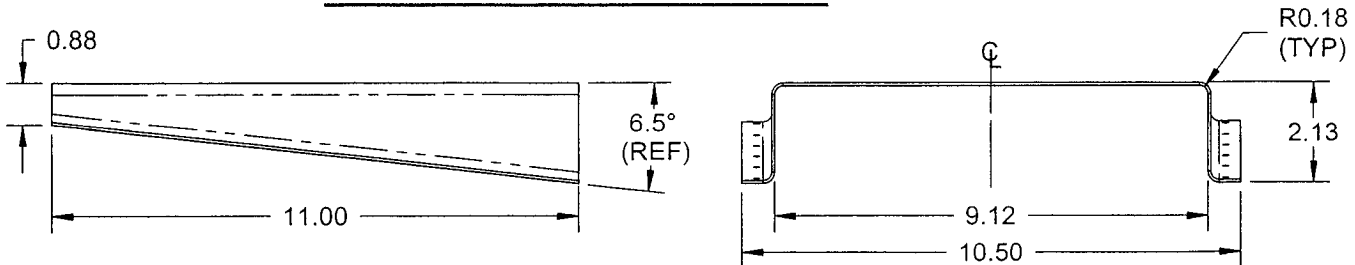
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3471	REV. A SHEET 3 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:4



D3471-1F BASE FLAT PATTERN



D3471-1 BASE BENDING DETAIL

NOTES:



- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

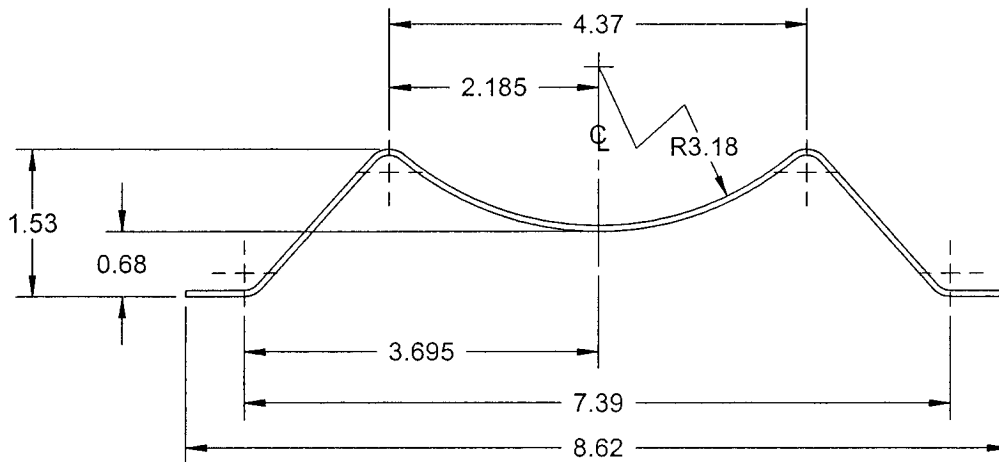
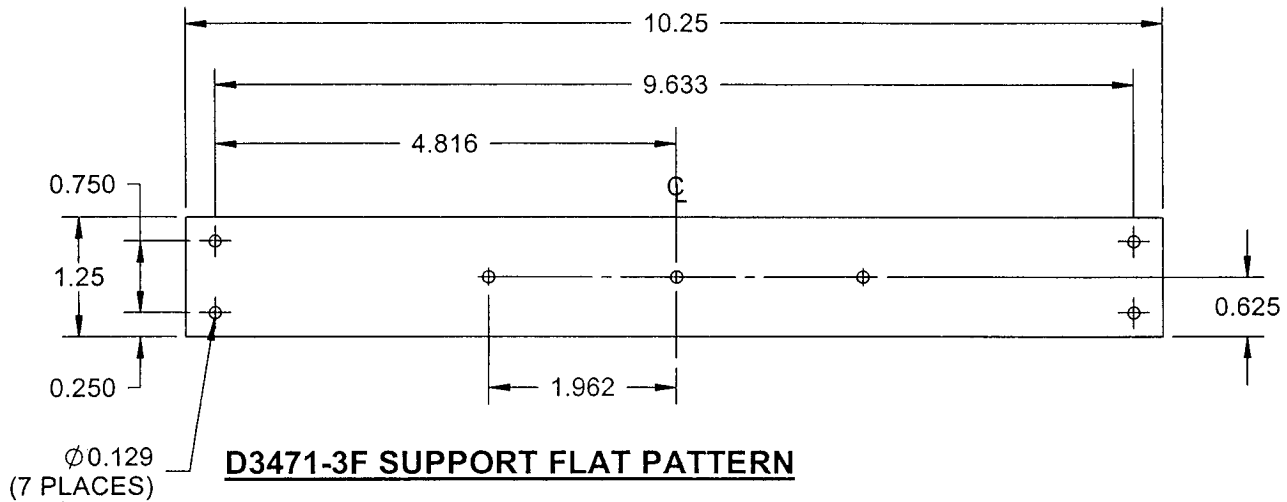
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26268

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

PRELIMINARY ISSUE

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3471	REV. A SHEET 4 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT SCALE 1:2	



NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

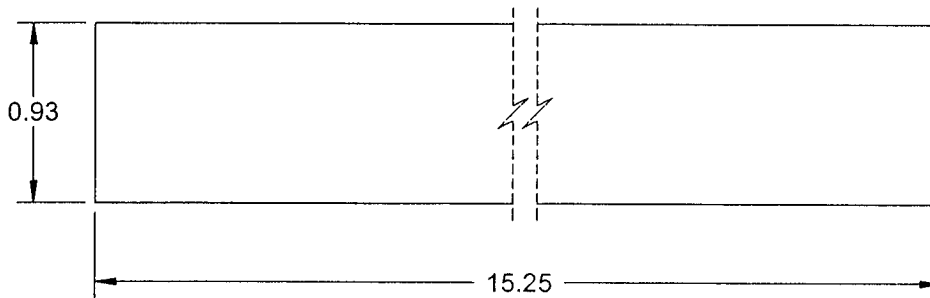
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26268

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

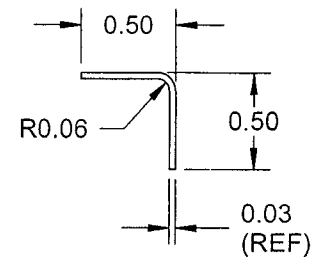
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3471	REV. A SHEET 5 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:1



D3471-5F STIFFENER FLAT PATTERN



**D3471-5 STIFFENER
BENDING DETAIL**

D3471-5 STIFFENER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *26268*

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

